

Work Order ID 148522

July 04, 2016 2:18:21 PM

148522

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Item ID: D350-607-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: AS350/355 Basket Mounting System

Start Date: 7/4/2016 Start Qty: 2.00

2 4
2 4

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: SLA Date: 7/4/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D350-607-241
CHG001
Paperwork not req'd if packaged with basket

0.00

JUL 06 2016

4x DAS
28
9-89

JUL 07 2016

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

4x PC

JUL 06 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.01

4x DAS
28
9-89

JUL 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Item ID: D350-607-241 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: AS350/355 Basket Mounting System Stop *NS2*

Start Date: 7/4/2016 Start Qty: 2.00 *2*

Required Date: 7/15/2016 Req'd Qty: 2.00 *2*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						4	DAS		JUL 07 2016
Packaging	Memo	0.00					28		
Packaging	Identify and pack for shipping as per PPP D350-607-241						9-89		
	Location: <u>St 366</u>								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

SA 7/8/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 148522

148522

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 7/4/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
as per ECN10-545 DD 10.04.16 verified by:EC
AS PER IIN REV.A DD VERF:JLM
IPP Rev:B
IPP REV:C 13.08.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2230-1		Manufactured	No			110	Each	108.0000	4	86			
---------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

D2230-1
Mounting Lug

**

PC



Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
----	---	--

84136	4	
-------	---	--

ST521	4	
-------	---	--

115306	1	
--------	---	--

140536	3	
--------	---	--

ST525A	100	
--------	-----	--

145246	100	
--------	-----	--

13
816

D2230-3		Manufactured	No			110	Each	346.0000	4	16			
---------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

D2230-3
Mounting Lug

**

PC



Location	Loc Qty	Loc Code
----------	---------	----------

FG	8	
----	---	--

109344	4	
--------	---	--

89045	4	
-------	---	--

ST521	138	
-------	-----	--

144487	58	
--------	----	--

145363	80	
--------	----	--

ST525A	200	
--------	-----	--

146287	200	
--------	-----	--

16

DAS
28
9-89

JUL 06 2016

Picklist Print

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Work Order ID: 148522

148522

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 7/4/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

D2732 2732-030 Manufactured No

110 f

287.3947 2

D2732

Rubber Cushion (\$per foot)

28

P2

8X 3" per kit SP

DAS
28
9-89

Location

Loc Qty

Loc Code

ST412

287.3947358

117118

5E-10

143793

287.394736

4

1- cut qty (8) 3.00" long per dwg D2732-030

AN4-15A

Purchased

No

110 Each

402.0000 8

16 32

P2

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

26

120449

26

over003

350

m134955

150

m135127

200

ST343

26

m134762

26

60X

26X

DAS
28
9-89

Picklist Print

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Work Order ID: 148522

148522

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 7/4/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

3,463.000

16

32 64

NAS1149D0463.J

WASHER

64

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	86
M132035	21
M134508	65
ST260a	3000
M134852	1000
M134943	1000
M135056	1000
ST263	377
M127693	24
M134754	353

MS21042L4

Purchased

No

110

Each

2,981.000

8

16 32

MS21042L 4

Locknut

32

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	51
m133363	51
GA	156
m133769	156
OVER007	1500
m134955	500
m135127	1000
ST303	1180
m127376	12
m134861	668
m135058	500
ST305	94
m130922	94

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Shop Packet Print

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6.2 D350-607-045/-045A/-047/-047A HELI-UTILITY-BASKET™

Qty -045	Qty -045A	Qty -047	Qty -047A	Qty -241	Part Number	Description
X					D350-607-045	HELI-UTILITY-BASKET
	X				D350-607-045A	HELI-UTILITY-BASKET
		X			D350-607-047	HELI-UTILITY-BASKET
			X		D350-607-047A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
1	1	1	1		D3265-041	BASKET BASE ASSEMBLY
1	1				D3266-041	BASKET LID ASSEMBLY
		1	1		D3267-041	BASKET LID (OUTSIDE)
		1	1		D3267-043	BASKET LID (INSIDE)
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
	1				D350-607-145	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

Work Order ID 148522

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Page 1

Item ID: D350-607-241

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/355 Basket Mounting System

Start Date: 7/4/2016 Start Qty: 2.00

2 4
2 4

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: SLA Date: 7/4/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-241 CHG001 Paperwork not req'd if packaged with basket								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

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DAS
21 JUL 06 2016
9-89
4